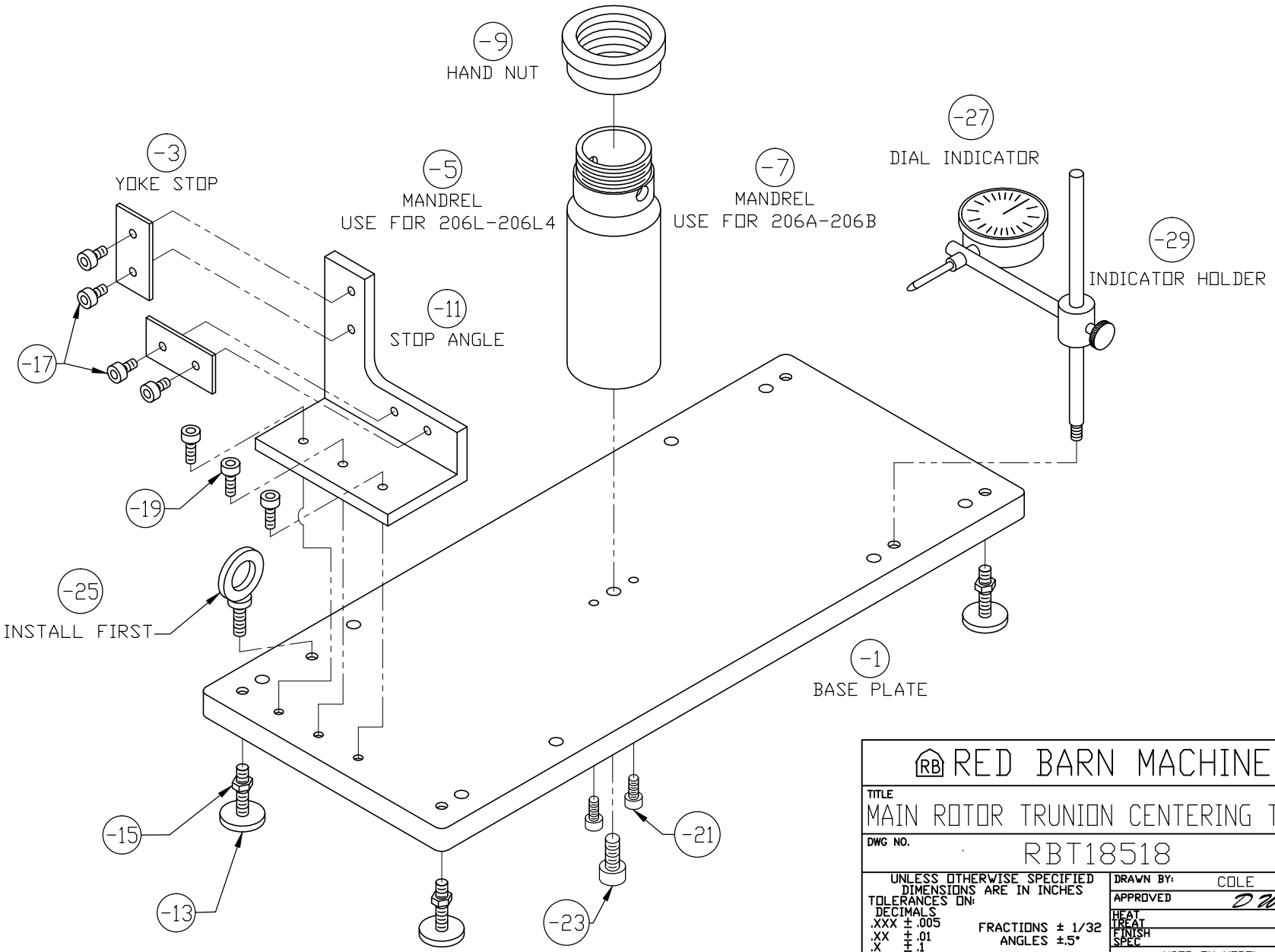


RED BARN MACHINE

TITLE
MAIN ROTOR TRUNION CENTERING TOOL

DWG NO. RBT18518 REV 4A

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS
.XXX ± .005
.XX ± .01
.X ± .1
FRACTIONS ± 1/32
ANGLES ±.5°

DRAWN BY: COLE
APPROVED D Weil
HEAT TREAT
FINISH SPEC

UNLESS OTHERWISE SPECIFIED
1. BREAK ALL SHARP EDGES
.015 x 45° PR .015 R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

USED ON MODEL
BELL 206A & 206B;
206L & 206L-4

SCALE NTS | DATE 10-22-01 | SHEET 1 of 8

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	−1 HOLE DIA. INCREASED TO ø.257. −3 STOCK SIZE CHANGED TO ENSURE SLEARANCE ON INSIDE OF −11 STOP ANGLE.	10/22/01		
2	CHANGED −9 DIMEMSION ø2.5 TO ø2.38. −11 DELETED STEEL SUBSTITION. ASSIGNED −#'S TO B/O ITEMS FOR CUSTOMER ASSEM. DRAWING CLARITY.	7/17/06	WP	DW
3	ADDED TO −7 & −5 MANDRELS A ø1.68 CENTER HOLE & A ø .44 CROSS HOLE. ALSO CORRECTED ADDRESS AND IMPLIMENTED NEW REV. TABLE, TITLE BLOCK, & BOM. ALSO −5 & −7 SHALLOWED 1/4−28 DEPTH FROM 1 in., & 3/8−24 FROM 1−1/4 in, (PER GABE). −21 & −23 SCREWS WERE 1−1/2 LONG. ADDED MISSING DIMENSIONS TO −1 & ORGANIZED. ALSO CHANGED B/O −27 & −29 FROM ENCO #605−4205 & #505−1848.	2/15/08	WP	DW
4	CH'D ALL ø.375 HOLES TO THRU HOLES (x9) P/N −1 PER G.E.	10/8/10	RJC	
4A	MOVED MACHINE ENGRAVED INFO TO SIDE OF PLATE PER G.E.	9/22/11	RJC	

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MAT.	B/O INFORMATION OR SPECIFICATIONS	Pg.
			−1	1	BASE PLATE PLATE	6061	3/4 x 9−3/16 x 22−3/16	3
			−3	2	YOKE STOPS GROUND PLATE	O−1 OR A−2	1/8 x 1 x 2−1/2 MSC #06108104 OR EQUIV.	4
			−5	1	MANDREL RND. BAR	S P	ø2−1/2 x 7−1/8	5
			−7	1	MANDREL RND. BAR	S P	ø2−1/2 x 7−1/8	6
			−9	1	HAND NUT RND. BAR	S P	ø2−3/4 x 1	7
			−11	1	STOP ANGLE ANGLE	6061	3/8 x 3 x 5 x 5−1/8 LENGTH	8
		B/O	−13	4	FEET W/NYLON BASE GLIDES	PLTD	MSC #06870604 or REID #IG−3	1
		B/O	−15	4	JAMB NUT	PLTD	5/16−18 UNC	1
		B/O	−17	4	BUTTON SOCKET HEAD CAP SCREW	BLK	1/4−20 UNC x 1/2	1
		B/O	−19	3	SOCKET HEAD CAP SCREW	BLK	1/4−20 UNC x 3/4	1
		B/O	−21	2	SOCKET HEAD CAP SCREW	BLK	1/4−28 UNF x 1−1/4	1
		B/O	−23	1	SOCKET HEAD CAP SCREW	BLK	3/8−24 UNF x 1−1/4	1
		B/O	−25	1	EYEBOLT	BLK	ø7/8 ID.; ø1−7/16 OD.; 5/16−18 UNC MSC #08099020	1
		B/O	−27	1	DIAL INDICATOR, 2 in. RANGE, VERT. LUG AND INDICATOR HOLDER		PAC−WEST #SHAVP340	1
	ASSY #							

RED BARN MACHINE

TITLE
M/R TRUNION CENTERING TOOL B.O.M.

DWG NO. RBT18518 REV 4A

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS
.XXX ± .005
.XX ± .01
.X ± .1
FRACTIONS ± 1/32
ANGLES ±.5°

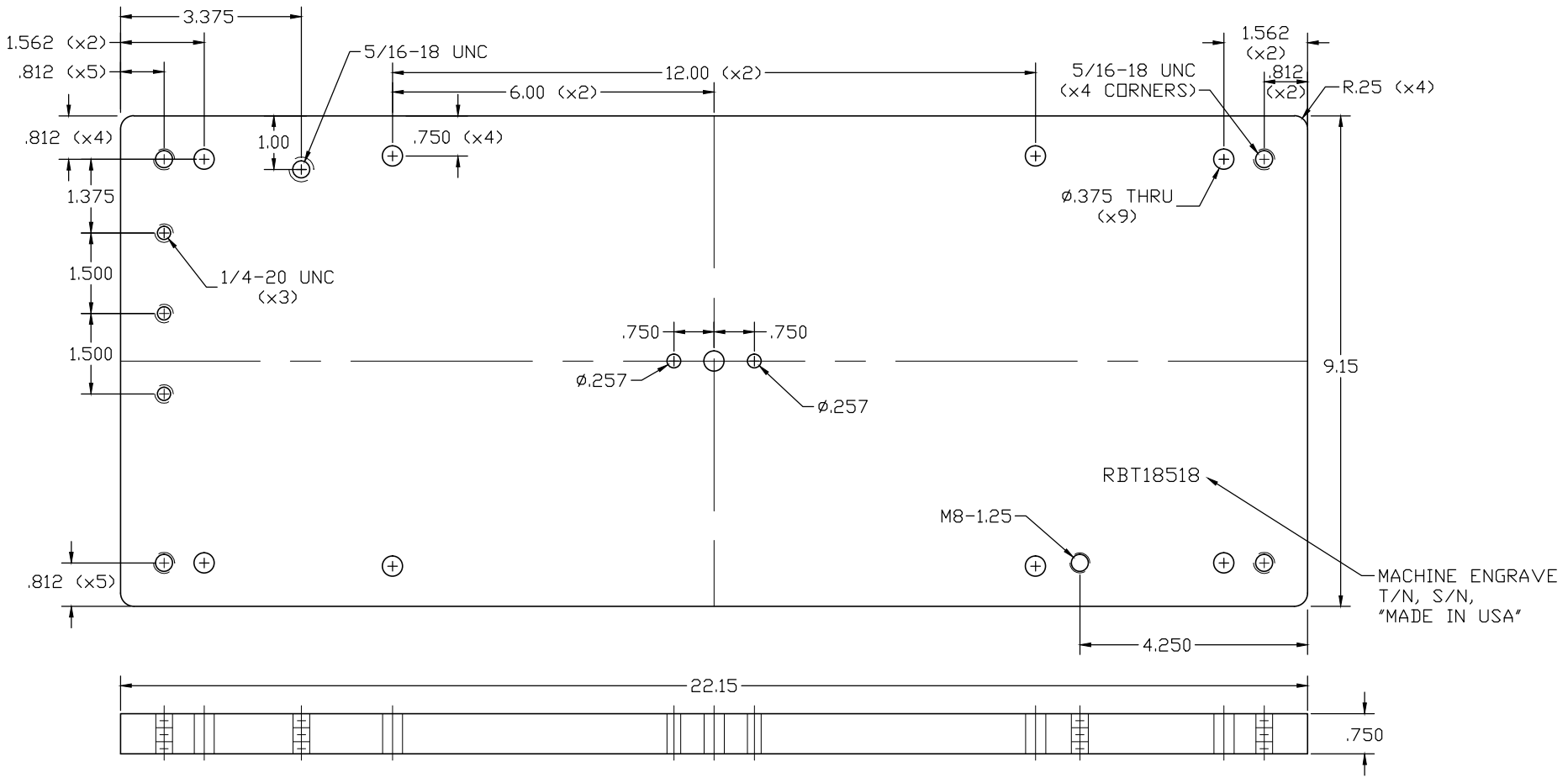
UNLESS OTHERWISE SPECIFIED
1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

DRAWN BY: COLE
APPROVED D Weil
HEAT TREAT
FINISH SPEC

USED ON MODEL
BELL 206A & 206B
206L & 206L−4

SCALE NTS DATE 10−22−01 SHEET 2 of 8

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
4	CH'D ALL ø.375 HOLES TO THRU HOLES (x9) P/N -1 PER G.E.	10/8/10	RJC	
4A	MOVED MACHINE ENGRAVED INFO TO SIDE OF PLATE PER G.E.	9/22/11	RJC	



-1

BASE PLATE

RED BARN MACHINE

TITLE: BASE PLATE

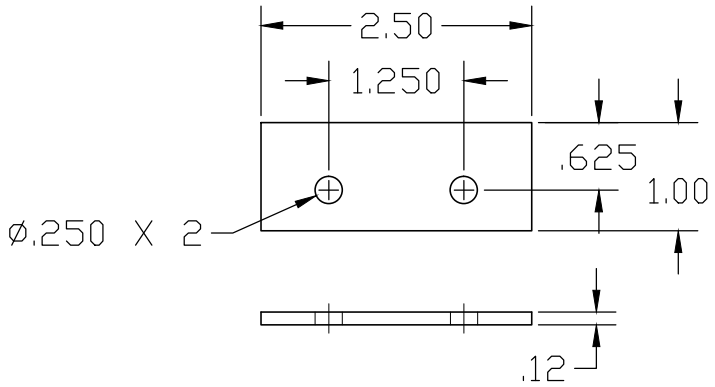
DWG NO. RBT18518-1 REV 4A

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS
.XXX ± .005
.XX ± .01
.X ± .1
FRACTIONS ± 1/32
ANGLES ±.5°

UNLESS OTHERWISE SPECIFIED
1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

DRAWN BY: COLE
APPROVED D Weil
HEAT TREAT
FINISH SPEC BLACK ANODIZED
USED ON MODEL
BELL 206A & 206B
206L & 206L-4

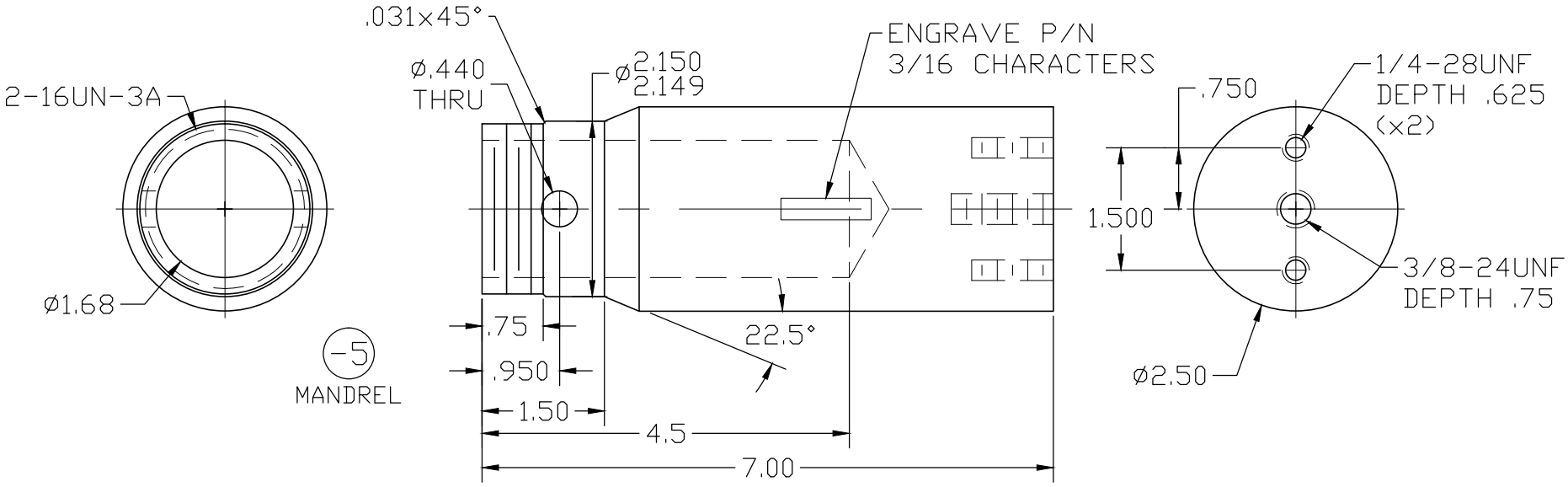
SCALE NTS | DATE 10-22-01 | SHEET 3 of 8



-3

YOKE STOP

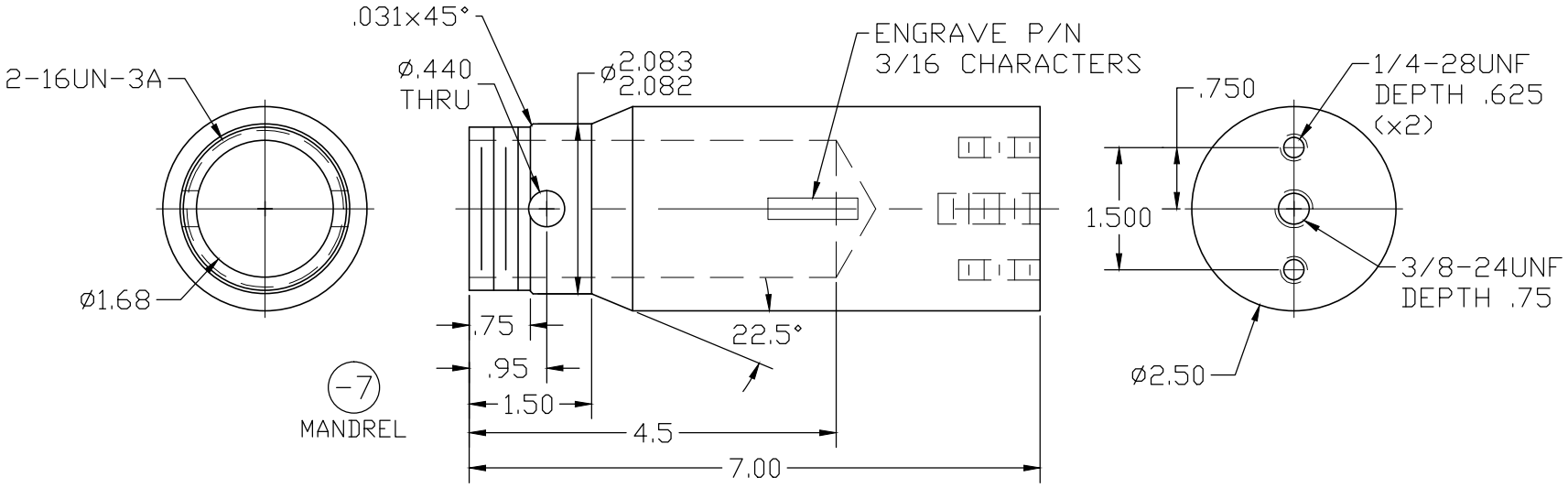
RED BARN MACHINE	
TITLE: YOKE STOPS	
DWG NO.: RBT18518-3	REV: 4A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ±.5°	DRAWN BY: COLE APPROVED: D Weil HEAT TREAT: FINISH SPEC: BLACK OXIDE
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL BELL 206A & 206B 206L & 206L-4
SCALE: NTS	DATE: 10-22-01
	SHEET: 4 of 8



NOTES

1. 2-16UN-3A INFORMATION;
   MAJOR PITCH ø1.9594
   MINOR PITCH ø1.9554
   OVER WIRES 2.0232 ±.002

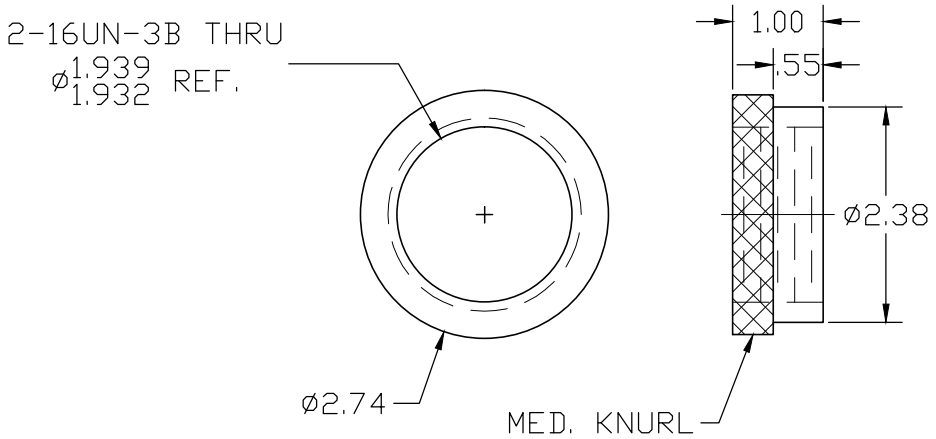
RED BARN MACHINE	
TITLE: MANDREL	
DWG NO.: RBT18518-5	REV: 4A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ±.5°	DRAWN BY: COLE APPROVED: D Weil HEAT TREAT: FINISH SPEC: BLACK OXIDE
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL BELL 206L & 206L-4
SCALE: NTS	DATE: 10-22-01
SHEET: 5 of 8	



NOTES

1. 2-16UN-3A INFORMATION;
   MAJOR PITCH ø1.9594
   MINOR PITCH ø1.9554
   OVER WIRES 2.0232 ±.002

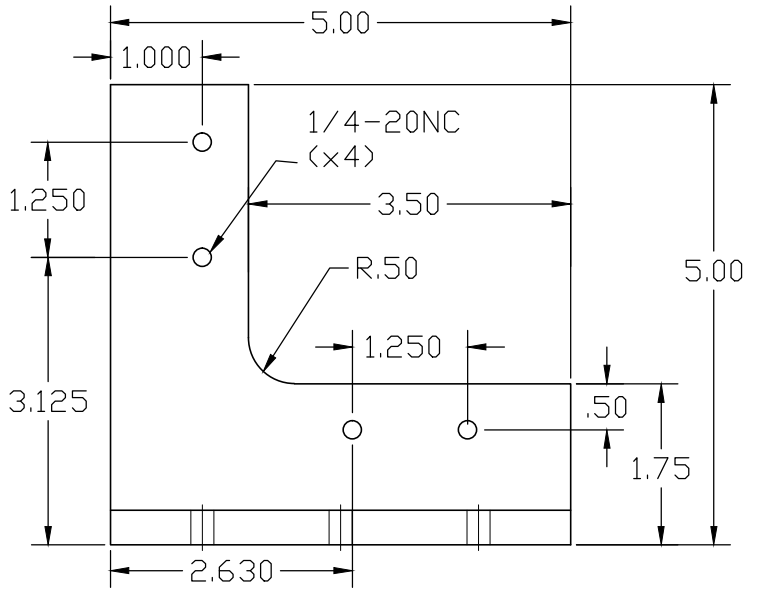
RED BARN MACHINE	
TITLE: MANDREL	
DWG NO.: RBT18518-7	REV: 4A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ±.5°	DRAWN BY: COLE APPROVED: D Weil HEAT TREAT: FINISH SPEC: BLACK OXIDE
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL: BELL 206A & 206B
SCALE: NTS	DATE: 10-22-01
SHEET: 6 of 8	

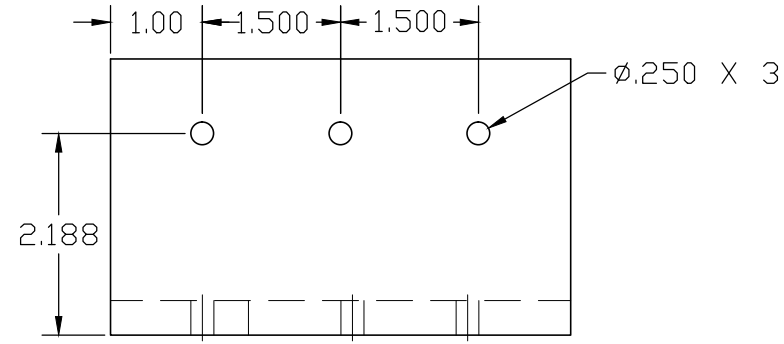


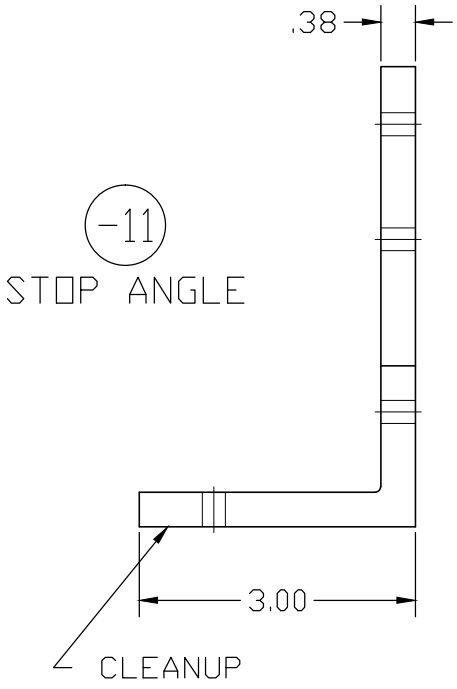
-9

HAND NUT

RED BARN MACHINE	
TITLE: HAND NUT	
DWG NO. RBT18518-9	REV 4A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ±.5°	DRAWN BY: COLE APPROVED: D Weil HEAT TREAT: FINISH SPEC: BLACK OXIDE
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL BELL 206A & 206B 206L & 206L-4
SCALE NTS	DATE 10-22-01
SHEET 7 of 8	



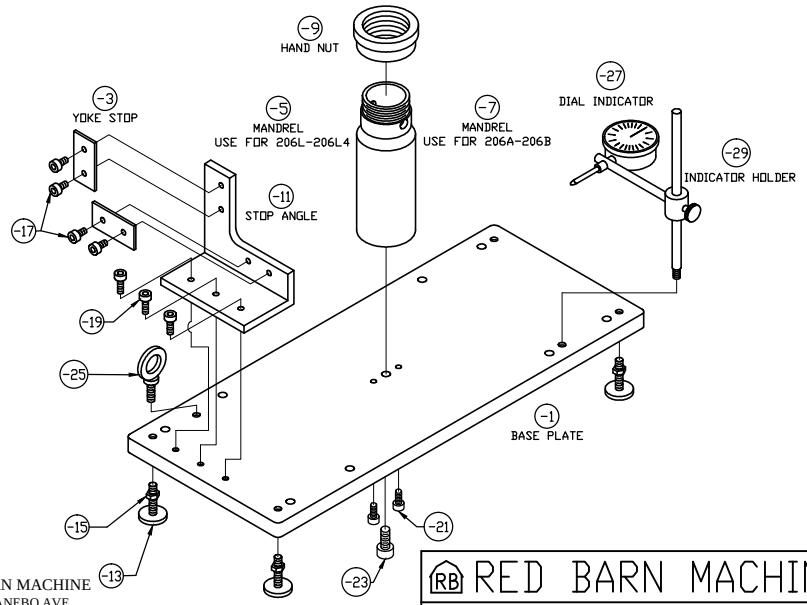




RED BARN MACHINE

TITLE	STOP ANGLE
DWG NO.	RBT18518-11
REV	4A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ±.5°	DRAWN BY: COLE
	APPROVED D Weil
	HEAT TREAT
	FINISH SPEC BLACK ANODIZE
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL BELL 206A & 206B 206L & 206L-4
SCALE NTS	DATE 10-22-01
	SHEET 8 of 8

MAIN ROTOR TRUNION CENTERING TOOL



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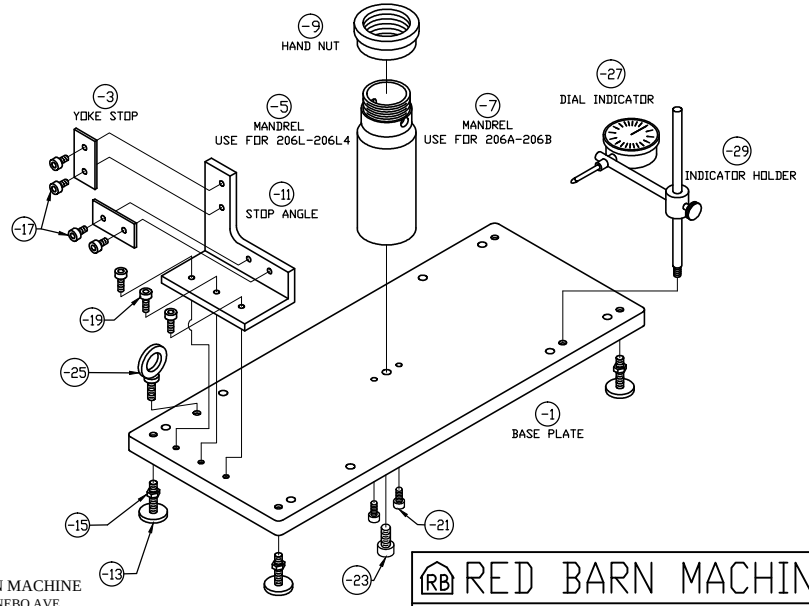
RBT18518

MAIN ROTOR TRUNION CENTERING TOOL



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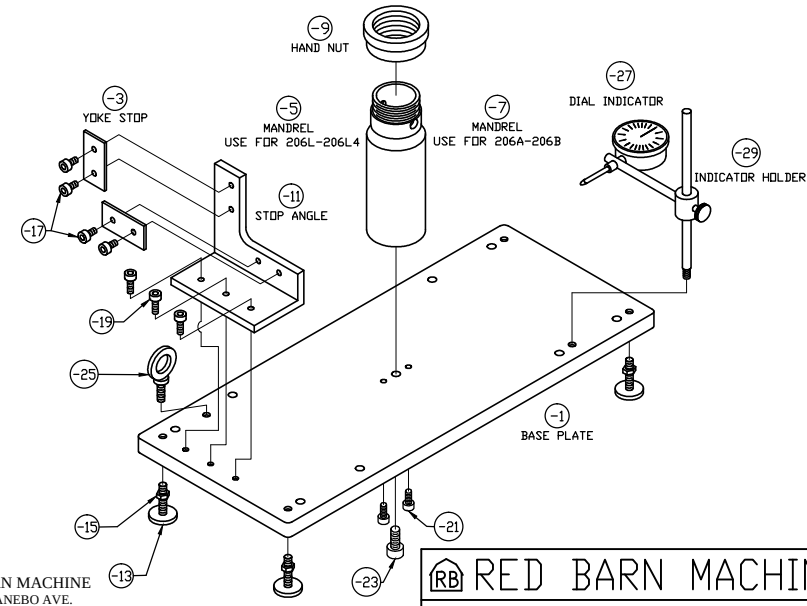

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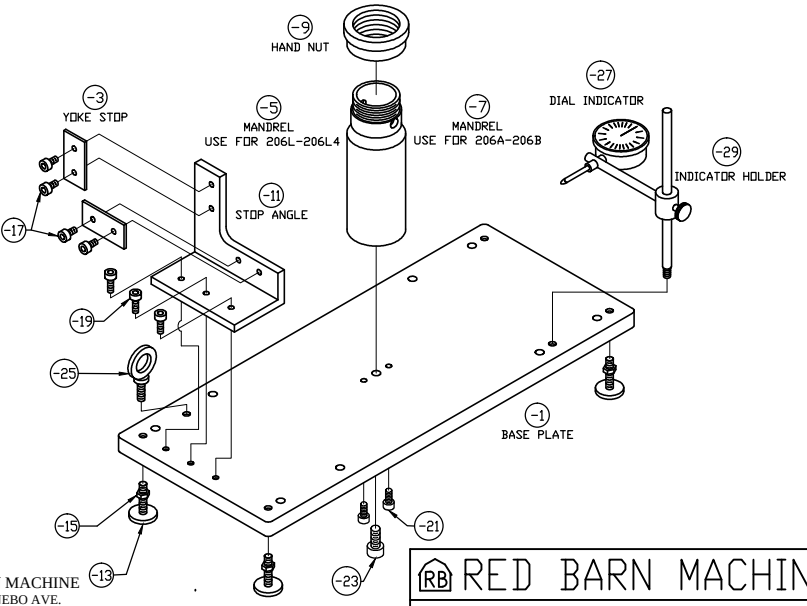

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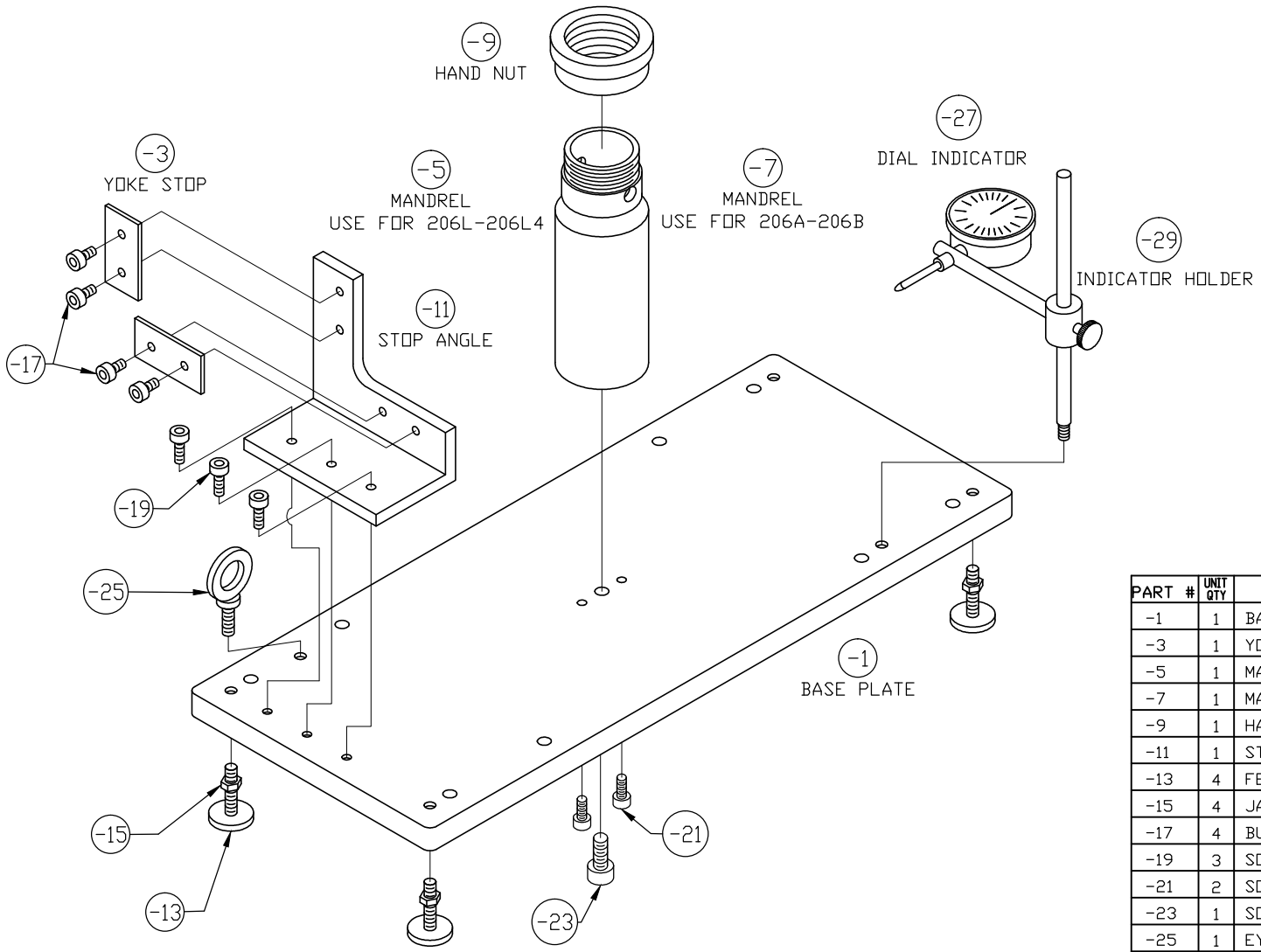

PART #	UNIT QTY	DESCRIPTION
-1	1	BASE PLATE
-3	1	YOKE STOPS
-5	1	MANDREL
-7	1	MANDREL
-9	1	HAND NUT
-11	1	STOP ANGLE
-13	4	FEET
-15	4	JAMB NUT
-17	4	BUTTON SOCKET HEAD CAP SCREW
-19	3	SOCKET HEAD CAP SCREW
-21	2	SOCKET HEAD CAP SCREW
-23	1	SOCKET HEAD CAP SCREW
-25	1	EYEBOLT
-27	1	DIAL INDICATOR & HOLDER

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